

**Work Order ID 110580**

Thursday, January 02, 2014 10:14:08 AM

**\*110580\***

Page 1

Item ID: D4881-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Leg Assembly, LH

Start Date: 1/2/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: NLF Date: 14-01-02

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4881	A								

110

0.00

**\*110\***

Small Fab

Memo

0.00

Small Fab

ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND  
D4885-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER  
DWG.  
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP  
DT9973 AS PER DWG.

FF  
14-04-15

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

AS  
27  
-88  
14/4/15

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**\*110580\***

Page 2

Item ID: D4881-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Aft Leg Assembly, LH

Stop **\*NS2\***

Start Date: 1/2/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL  
WET AS PER DWG USE DT9973  
A/R HYSOL BATCH: 11120703

DAS

27

59

FF  
14-04-15

140

0.00

**\*140\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

14/4/16

150

0.00

**\*150\***

Packaging

Identify as per dwg & Stock Location: 51139B

Memo

0.00

Packaging

DAS  
28  
9-89

1X

APR 16 2014

**Work Order ID 110580**

Thursday, January 02, 2014 10:14:08 AM

**\*110580\***

Page 3

Item ID: D4881-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Aft Leg Assembly, LH

Stop **\*NS2\***

Start Date: 1/2/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

1/14-4-17  
4-04-16

# Picklist Print

Thursday, January 02, 2014 10:14:07 AM

Page 1

Work Order ID: 110580

Parent Item: D4881-041

Parent Item Name: Aft Leg Assembly, LH

Start Date: 1/2/2014

Required Date: 1/31/2014

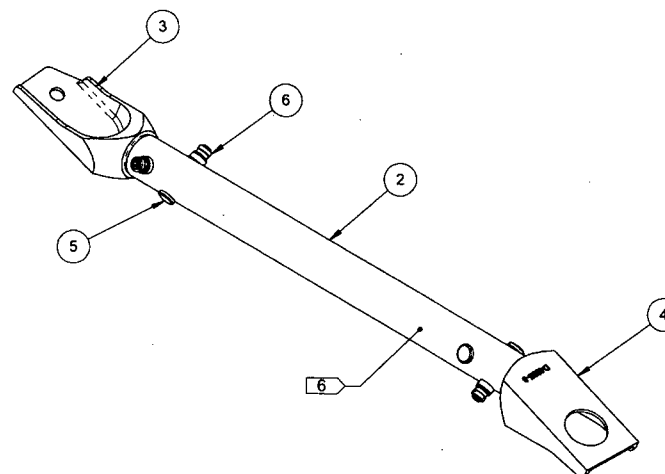
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4881-1 Strut		Manufactured	No	111339			Each	0.0000		1	FF	14-04-15	
D4885-1 End Fitting		Manufactured	No	112032			Each	0.0000		1	FF	14-04-15	
D4885-3 End Fitting		Manufactured	No	112034			Each	0.0000		1	FF	14-04-15	
HL20PB5-12 Rivet		Purchased	No	128110			Each	0.0000		4	FF	14-04-15	
HL86-5 Collar		Purchased	No				Each	21.0000		4	FF	14-04-15	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST283	128110	21							
				121866		21							

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



**D4881-041 AFT LEG ASSEMBLY, LH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.72 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø 0.1610) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

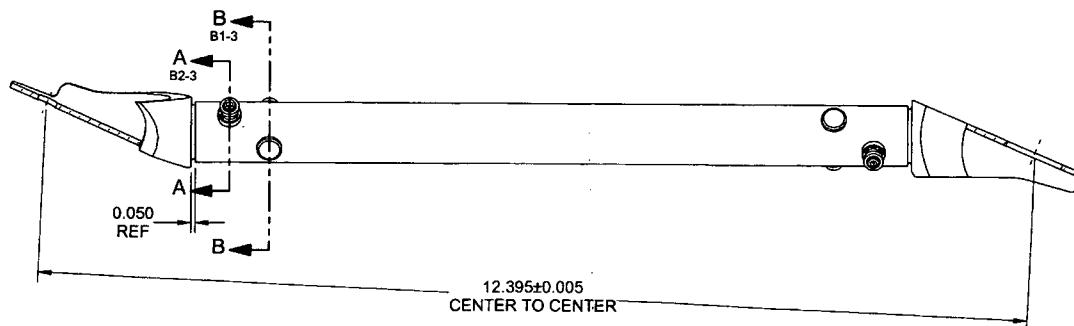
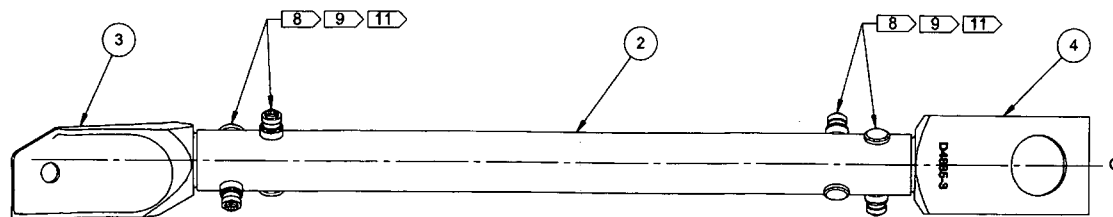
*MF*  
14-01-08  
# 110580

2013-12-12  
*W*

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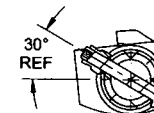
A		NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 5	
DRAWN	RF				
CHECKED	DC	DRAWING NO.		TITLE	
MFG. APPR.	JLM	D4881		LEG ASSEMBLY	
APPROVED	HS	DATE		SCALE	
DE APPR.	DS	13.12.09		NTS	

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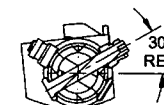


**D4881-041 AFT LEG ASSEMBLY, LH**  
AUXILIARY VIEW

#110580



**SECTION A-A** C7-3  
2 PL SIMILAR

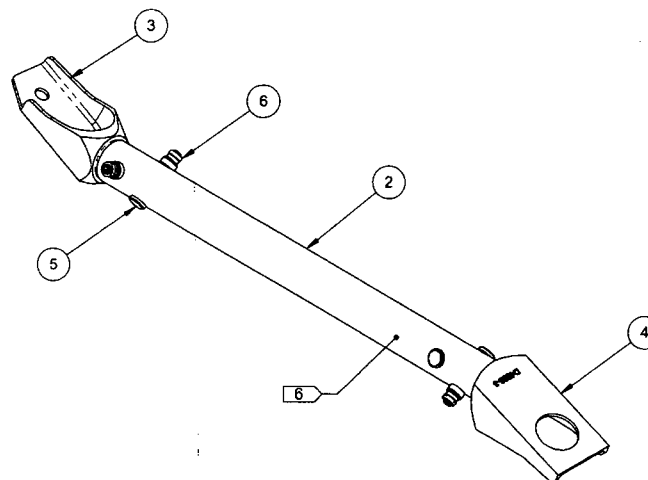


**SECTION B-B** C7-3  
2 PL SIMILAR

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM	TITLE <b>LEG ASSEMBLY</b>	SHEET 2 OF 5
APPROVED	HS		SCALE
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ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4881-042	AFT LEG ASSEMBLY, RH
2	1	D4881-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



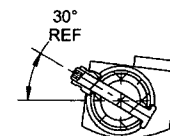
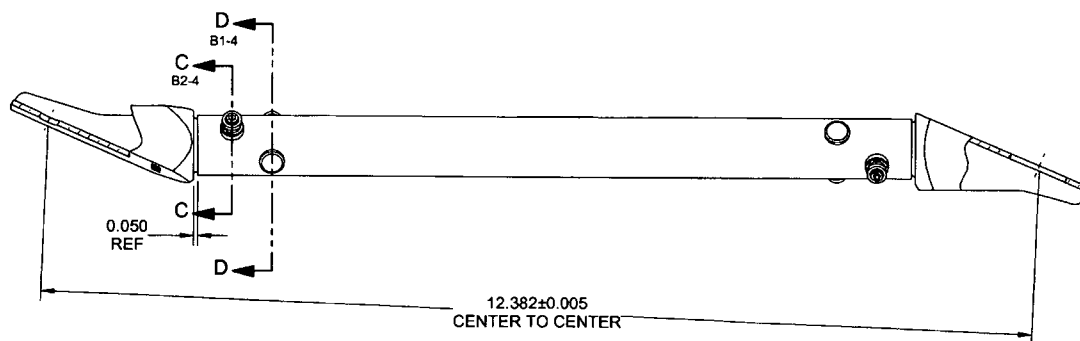
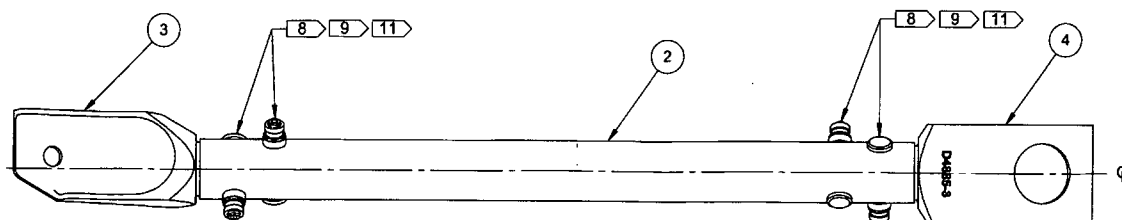
**D4881-042 AFT LEG ASSEMBLY, RH**

**NOTES:**

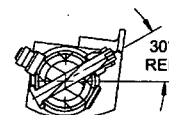
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.78 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9974
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9974
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM	TITLE <b>LEG ASSEMBLY</b>	SHEET 3 OF 5
APPROVED	HS	SCALE NTS	
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**SECTION C-C** C7-4  
2 PL, SIMILAR



**SECTION D-D** C7-4  
2 PL, SIMILAR

**D4881-042 AFT LEG ASSEMBLY, RH**  
AUXILIARY VIEW

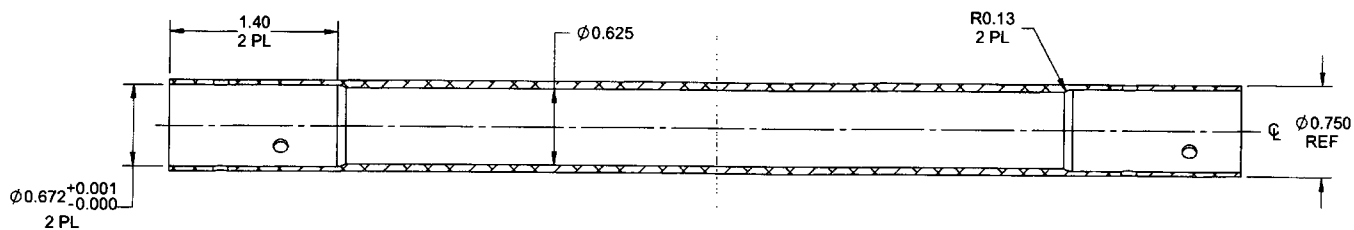
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DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM	TITLE <b>LEG ASSEMBLY</b>	SHEET 4 OF 5
APPROVED	HS		SCALE
DE APPR.	DS		NTS
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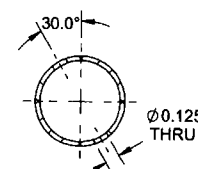
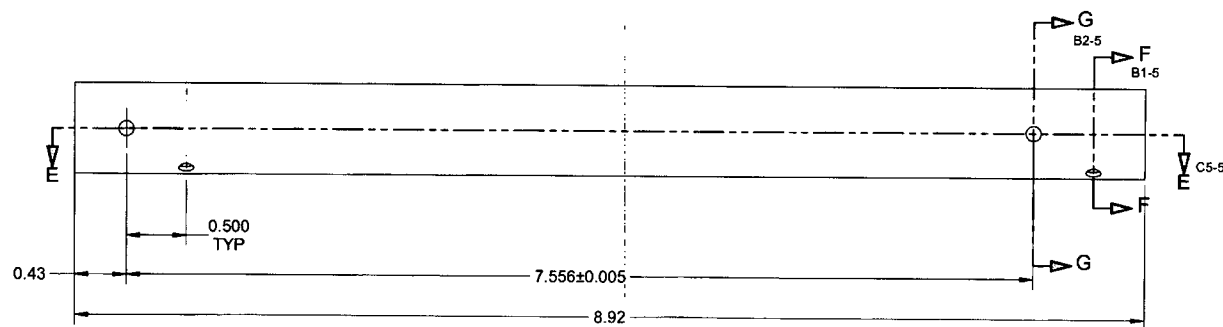
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2013-12-12

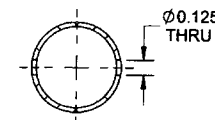




**SECTION E-E** B3-5



**SECTION F-F** C3-5  
2 PL



**SECTION G-G** C3-5  
2 PL

**D4881-1 STRUT**

**NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM	TITLE <b>LEG ASSEMBLY</b>	SHEET 5 OF 5
APPROVED	HS		SCALE
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# 110580

RELEASED  
2013-12-12